

Date: Tuesday, 19/08/2008 4:04:52 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER		
Job Number	: 41451		Part Number	: D32783		
Estimate Number	: 11167		Drawing Number	: D3278 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 19/08/2008	S.O. No. :	Drawing Revision	: C		
Prsh Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 08/09/2008	Qty:	40
Previous Run	: 40355		Um:	Each		
Written By	:					
Checked & Approved By	: <u>JUL 08.8.19</u>					
Comment	: Est. A 04.04.19 New issue KJ/JLM Est B 07.09.06 Rev C dwg EC Verified by: JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MDELRINS0125	Black Delrin Sheet .125
Comment: Qty.: 0.0361 sf(s)/Unit Total : 1.4448 sf(s) Black Delrin Material: Black Delrin/UHMW 0.125" thick (M-DELRIN-S0.125x30.0) Identify for D3278-3 Batch: <u>15607</u> <u>B 8-8-25</u>		
2.0	WATER JET	FLOW WATER JET <div style="text-align: right;"> <u>08/08/25</u> <u>B8-8-25</u> </div>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>B8-8-25</u>
4.0	QC8	SECOND CHECK <u>08/08/27</u> <u>4883</u> <i>excellent</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'sink as per dwg D32783

→ *26/08/08 107* (88)

2-Deburr

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26/08/08 108 (108) counter

7.0 PACKAGING 1

PACKAGING RESOURCE #1



×88

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *81*

81/08/08

SP

8.0 QC21

FINAL INSPECTION/W/O RELEASE



88

Comment: FINAL INSPECTION/W/O RELEASE

26/08/08 109

Job Completion



26/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41451
Description: Spacer	Part Number:	D3278-3
Inspection Dwg: D3278	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

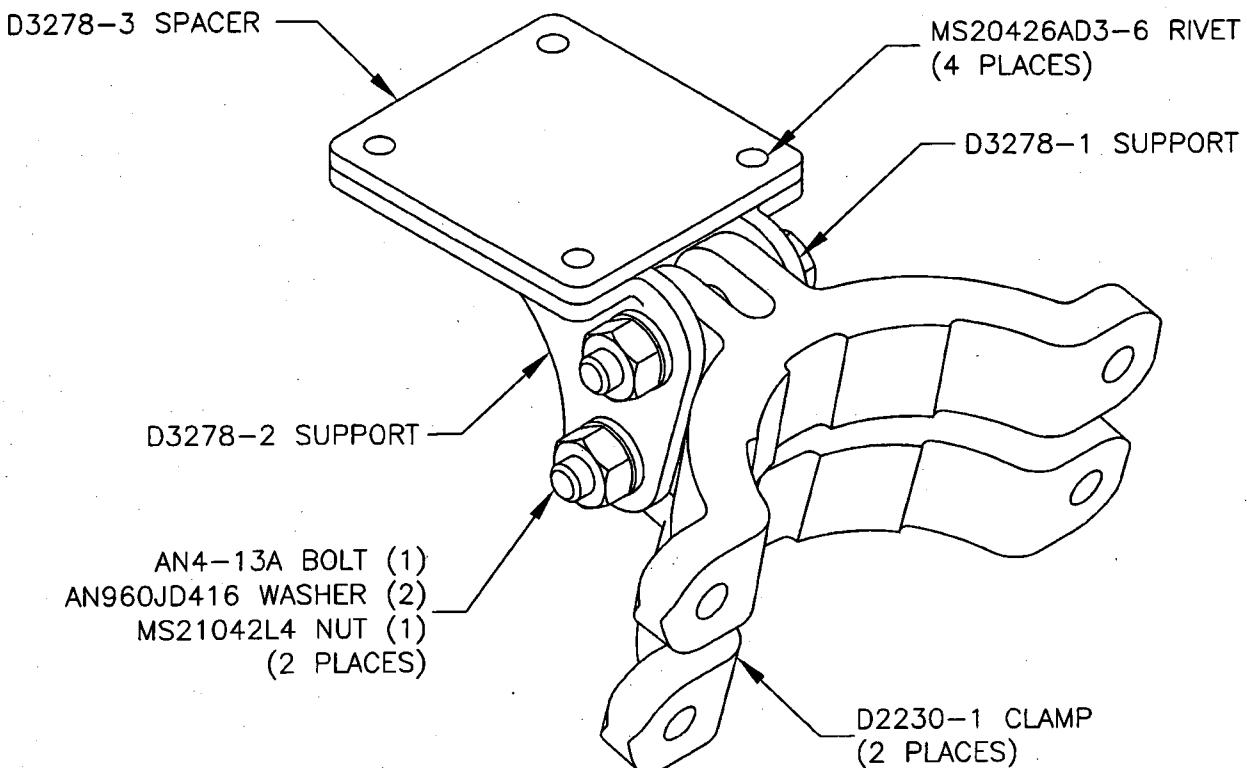
X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u> </u>	Prototype Approval: N/A
Date: <u>8-8-25</u>	Date: <u>08/08/27</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.02.02	Dwg updated per JLM	KJ/JLM	
D	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	<i>JK</i> <i>EC</i>

DART

DESIGN <i>91</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>JB</i>	APPROVED <i>LL</i>	DRAWING NO. D3278	REV. C	SHEET 1 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE NTS	
A	04.03.03	NEW ISSUE		
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT		
C	07.07.24	CHANGED RIVETS PER PAR #185		

RELEASED
*07.08.08*D3278-041 SUPPORT ASSEMBLY

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

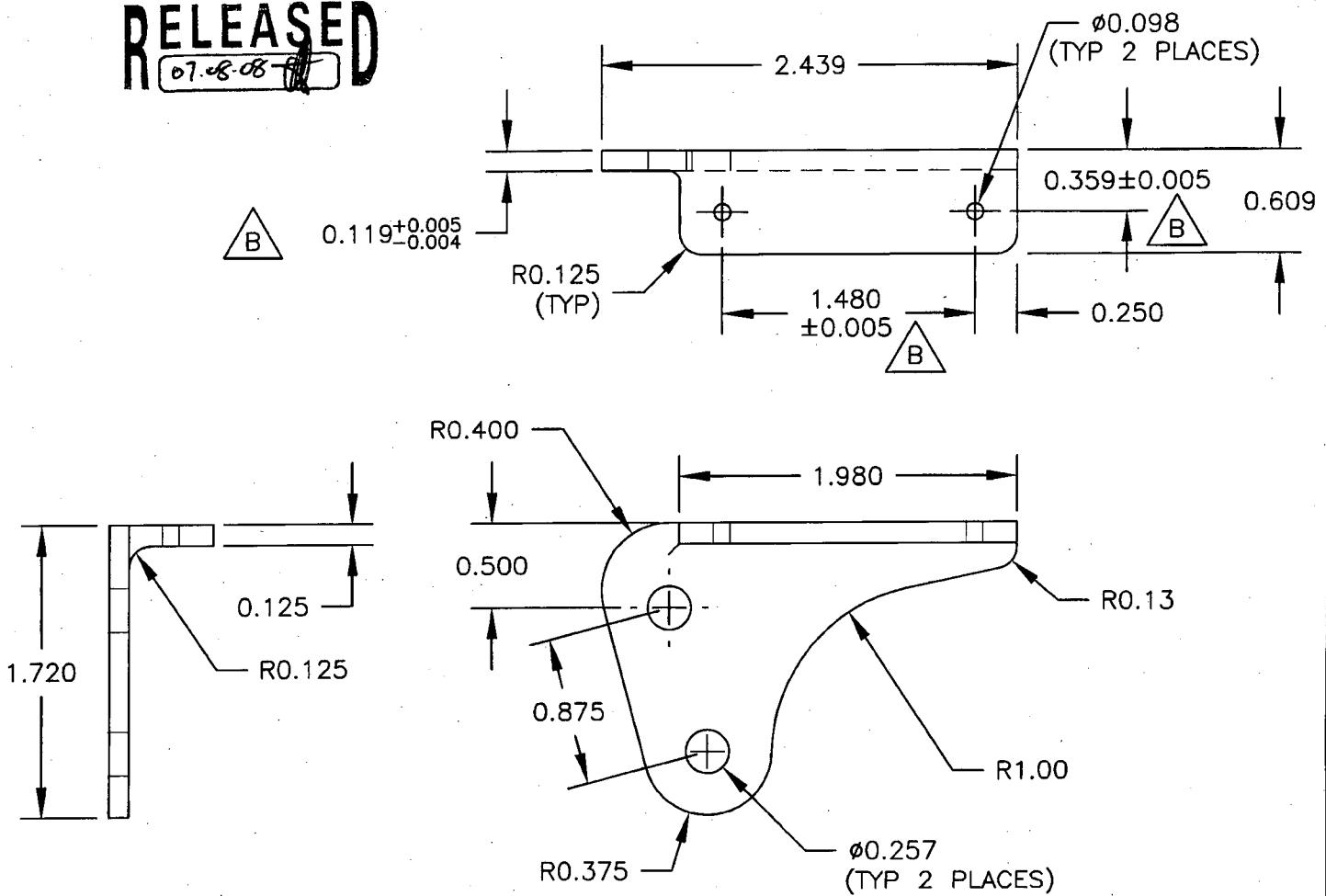
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DART

DESIGN <i>QP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AB</i>	APPROVED <i>HT</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

1) MACHINE PER DWG FILE "D3278-1.SLDPRT"

2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR

PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) *SHOP COPY*

PER AMS-QQ-A-200/8 (OR AMS 4160)

(REF. DART SPEC. M6061T6B)

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

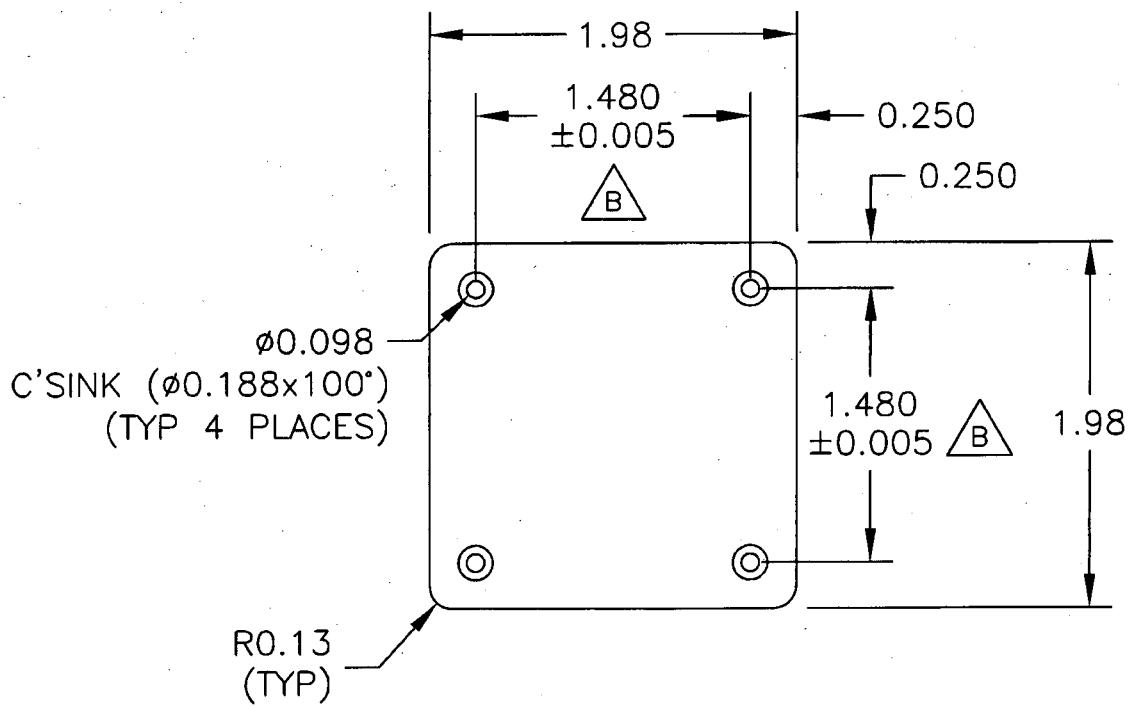
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DART

DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JB</i>	APPROVED <i>HF</i>	DRAWING NO. D3278
DATE 07.07.24		TITLE SUPPORT ASSEMBLY

REV. C
SHEET 3 OF 3
SCALE
1:1**RELEASED**
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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